

Work Order ID 57959

April 21, 2010 9:18:48 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: RIDate: 10-1-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A AG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch:

m112507
m112860

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 10-5-4

BE 10/05/04

DP 10-5-7

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	-	-	AWM 10-5-08
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							8/10/5/14
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							8/10/5/14

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ M113435 ☐

Sikaflex expire date: ☐ 10-11-30 ☐

Start: ☐ 10-5-11 ☐ Time: ☐ 11:30AM

Finish: ☐ ☐ Time: ☐

(Adhere for 12 hours)

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.								
	2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Debur								
	3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES								
	4- Countersink crossbolt spacer holes as per Dwg D3274								
	5- prepare for welding								
180 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

10/5/18

AM 10-05-19 (1)

h = 3.00
L = 4.60

8/10/19 (4)

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Stop

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Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S. 10/05/20

Memo

0.00

⑩

220



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

RECLAIMED - PAR09-043

0.00

①

BK 10-5-25.

230



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: 1:30 pm
OVEN TEMPERATURE: 320 °F
FINISH TIME: 2:00 pm

0.00

② M 10/05/25

1

②

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00



HandFinish

HAND FINISHING RESOURCE #1

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 113435

Sikaflex expire date: ☐ 10/11

3-Inspect for foreign objects as per QSI 024

4-Spray ~~inside of tube~~ on both sides of web with LPS-3

A/R LPS-3 Batch: _____

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 113435

Sikaflex expire date: ☐ 10/11

PROCYON 104257

① BK 10-5-27

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/05/28

④

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

Identify as per dwg & Stock Location: _____

0.00

PP 59776

10-4-15 SP



Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/17 JF

MF
10-6-17

W/O:		WORK ORDER CHANGES					
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Page 1

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2600-1-190

Manufactured No

110

Each

44.0000

1.0000



Extrusion Round 3" 206

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47575

110

Each

158.0000

1.0000

D3285-1

Manufactured No



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47635

52511

52647

158

9

74

75

150

Each

0.0000

1.0000

D3282-041

Manufactured No



Float Web (206L/407)

D2649

Manufactured No



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

55000

85

85

858545

x 12

BE 10/05/20

W/O:		WORK ORDER CHANGES					
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IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3275-1 Manufactured No 190 Each 20.0000 12.0000



Crossbolt Spacer

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	LG	20	
	53453	20	

①/2 BE 10/05/20

CR3212-4-03 Purchased No 250 Each 2,117.000 2.0000



Cherry Rivet

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST311	2117	
	111359	92	
	112314	125	
	114436	1900	

2 BL 10-5-27

D3415-041 Manufactured No 250 Each 75.0000 1.0000



Nut Plate

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST056	75	
	33842	75	

1 BL 10-5-27

April 21, 2010 9:18:53 AM

Shop Packet Print

Page 2

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IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased No

250

Each

724.0000 2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311

724

111548

4

112314

4

113539

92

113973 ✓

624

ALS4-1032-130

Purchased

No

250

Each

1,912.000 78.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

1912

110511

40

114407

1872

2 BR 10-5-27

78. BR 10-5-27

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Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No 270 Each 19.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 19

51600 7

56055 ✓ 12

D3536-23 Manufactured No 270 Each 16.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 4

53468 4

Main Warehouse

FP011 12

57529 ✓ 12

1 BR 10-5-27

1 BR 10-5-27

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IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3536-35 Manufactured No 270 Each 18.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 58637 6

51628 6

Main Warehouse

FP012 12

57530 12

D3536-39 Manufactured No 270 Each 11.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 11

48161 1

51637 10

1 BR 10-5-27

1 BR 10-5-27

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Required Date: 28/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Manufactured No

270

Each

14.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

14

53462

4

56053 ✓

10

D3535-35

Manufactured No

270

Each

16.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

5

51608

5

Main Warehouse

FP018

11

57528 ✓

11

1 Dr 10-5-27

1 Dr 10-5-27.

Picklist Print

April 21, 2010 9:18:53 AM

Page 7

Work Order ID: 57959

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-39 Manufactured No 270 Each 9.0000 1.0000



Wearshoe



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

9

51619 ✓

9

D3535-23 Manufactured No 270 Each 24.0000 1.0000



Wearshoe



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

11

53467

1

56054 ✓

10

Main Warehouse

FP21

13

57730

13

1 PR 10-5-27

1 BR 10-5-27

Picklist Print

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Page 8

Work Order ID: 57959



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No 270 Each 24.0000 1.0000



Wearpad



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 2

35697 2

Main Warehouse

FP17 22

57512 ✓ 22

D3537-1 Manufactured No 270 Each 51.0000 9.0000



Wearpad



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 57256 9

55465 9

Main Warehouse

FP17 57713 42

57510 42

AN960C10L Purchased No 270 Each 0.0000 80.0000



washer



NAS 1149C03322

114341 ✓

1 BR 10-5-27

5 BR 10-5-27

4 BR 10-5-27

80 BR 10-5-27

Picklist Print

April 21, 2010 9:18:53 AM

Page 9

Work Order ID: 57959

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C416

Purchased

No

270

Each

376.0000

1.0000



washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST346

376

100993 ✓

376

D3672-1

Manufactured

No

270

Each

1,581.000

2.0000



Phenolic Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

1581

47628 ✓

81

51674 ✓

500

52505

1000

1 BL 10-5-07.

2 BL 10-5-07

Picklist Print

April 21, 2010 9:18:53 AM

Page 10

Work Order ID: 57959



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 270 Each 1,799.000 80.0000



BOLT

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST350	114523	1799	
114103		501	
114108		300	
114330		498	
114416		500	

80 BL 10-5-27

AN4C5A Purchased No 270 Each 533.0000 1.0000



BOLT

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST346		533	
110552		33	
112243		500	

1 BL 10-5-27

Picklist Print

April 21, 2010 9:18:53 AM

Page 11

Work Order ID: 57959



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No 270 Each 32.0000 1.0000



Aft Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6 28

52663 28

Main Warehouse

fp7 4

52663 ✓ 4

D3413-1 Manufactured No 270 Each 31.0000 1.0000



Ring

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST473 31

51586 8

53446 23

58524 ✓

1 BL 10-5-27.

1 BL 10-5-27.

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 52959

P10-5-07

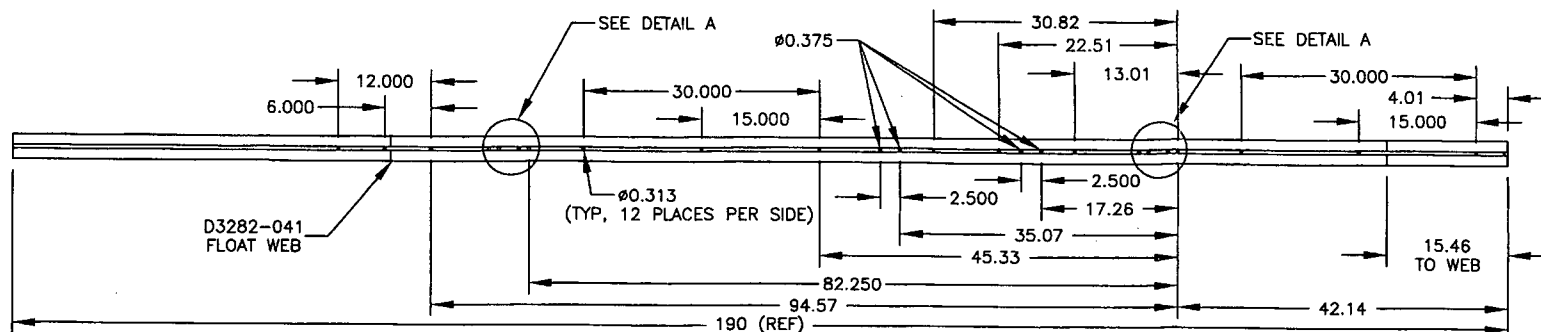
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

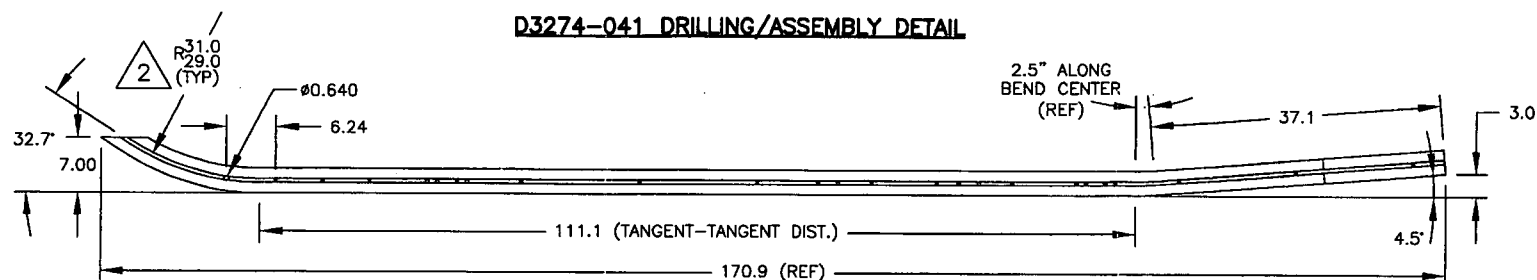
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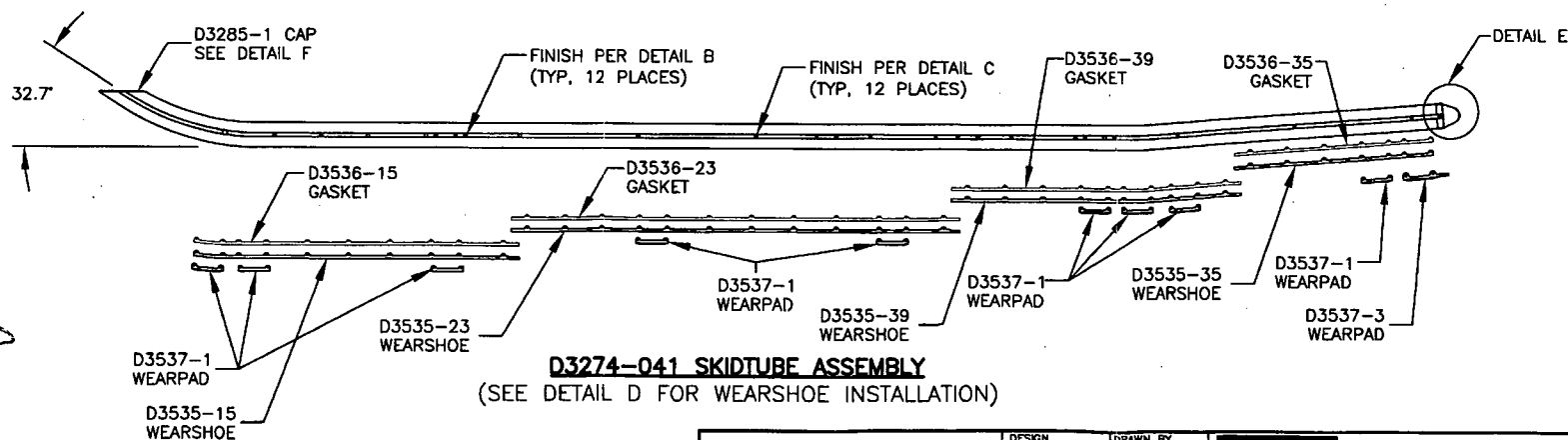
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

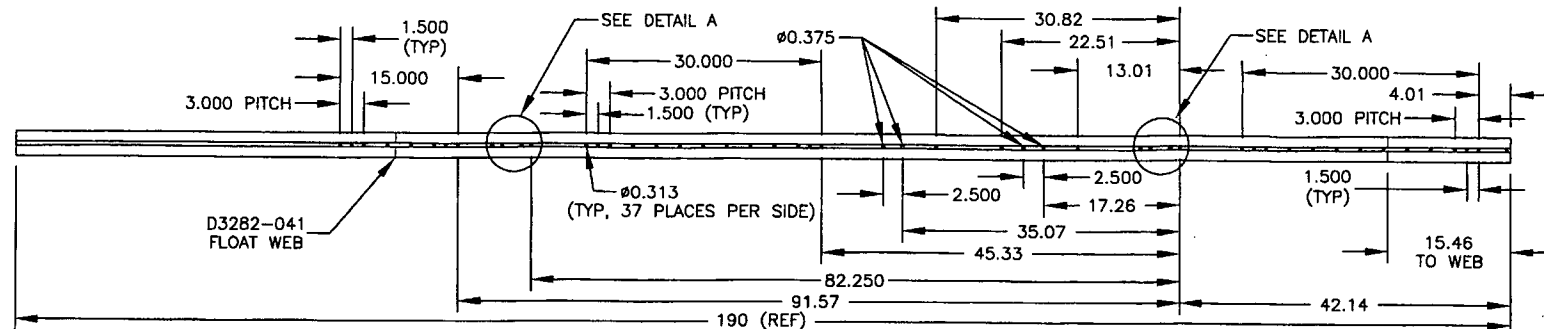
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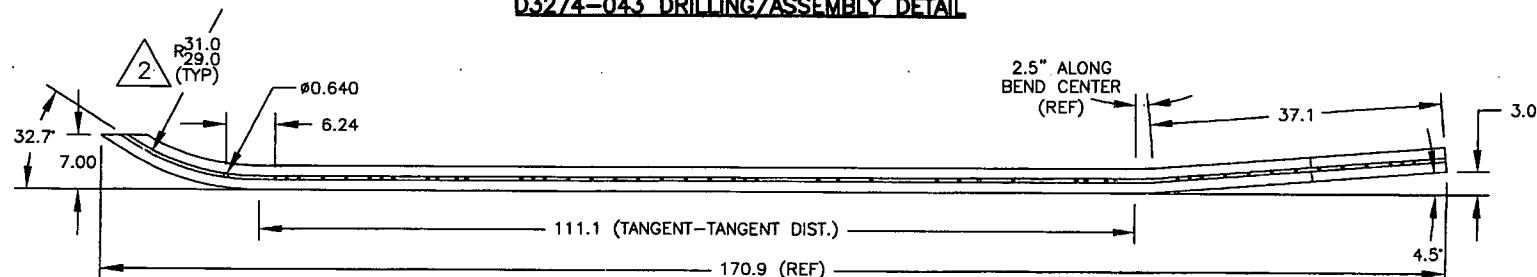
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT WADLOCK, MA
DATE	06.12.19	DRAWING NO.	D3274	REV. D
		TITLE	SKIDTUBE ASSEMBLY	SHEET 2 OF 4
				SCALE 1:15

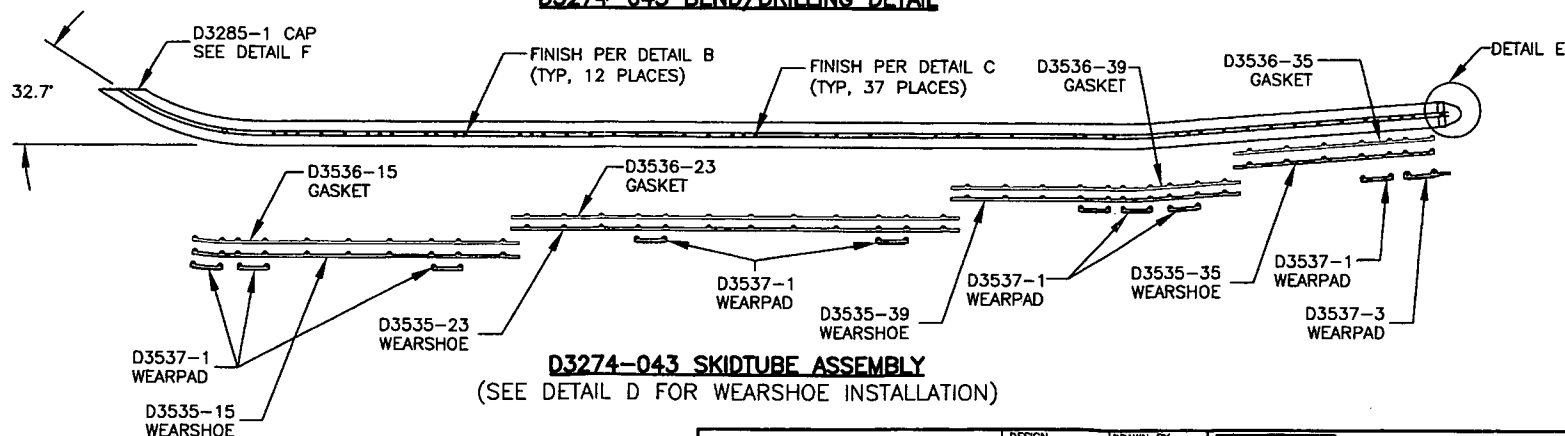
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

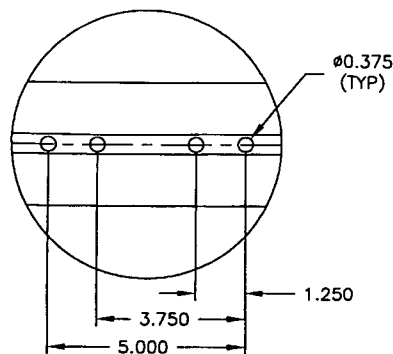
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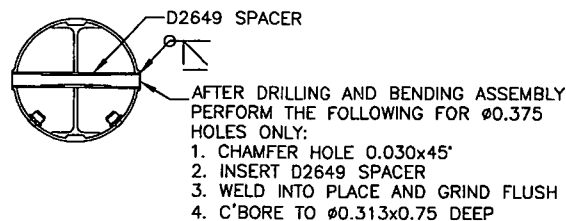
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DESIGN	CP	DRAWN BY	PH	DART	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	DRAWING NO.	D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D	SHEET 3 OF 4
				SCALE	1:15

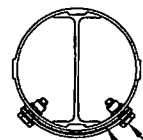
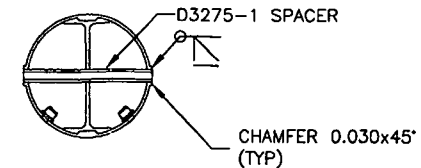
DETAIL A: DRILL DETAIL



DETAIL B FOR 0.375 HOLES ONLY



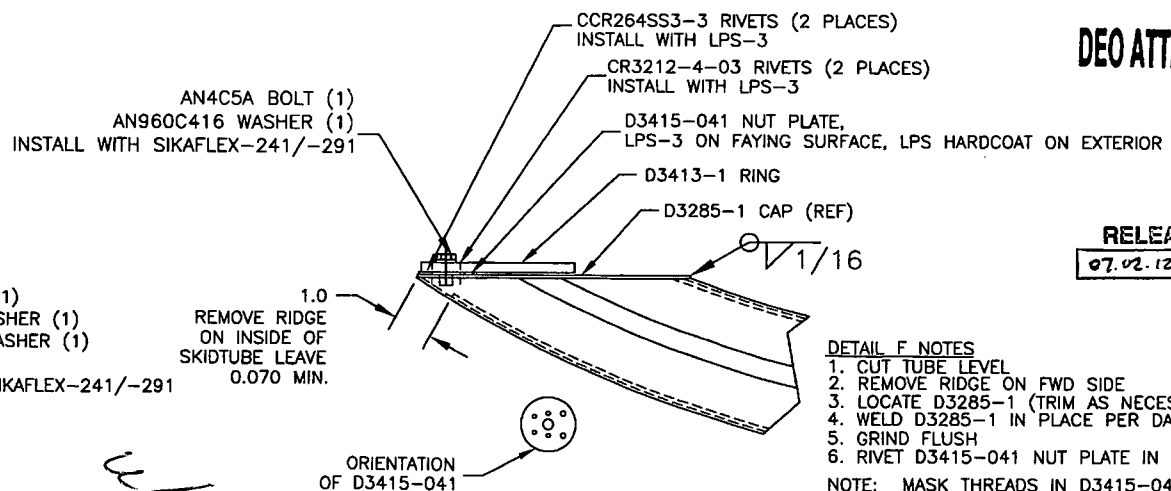
DETAIL C FOR 0.313 HOLES ONLY



DETAIL D

ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

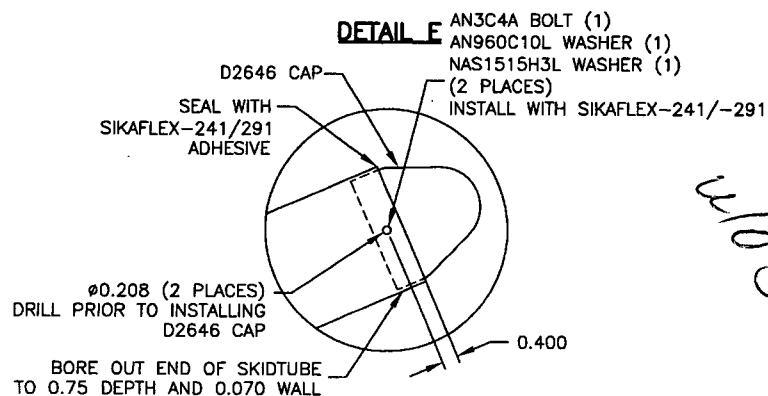
DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

DETAIL E



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:3	

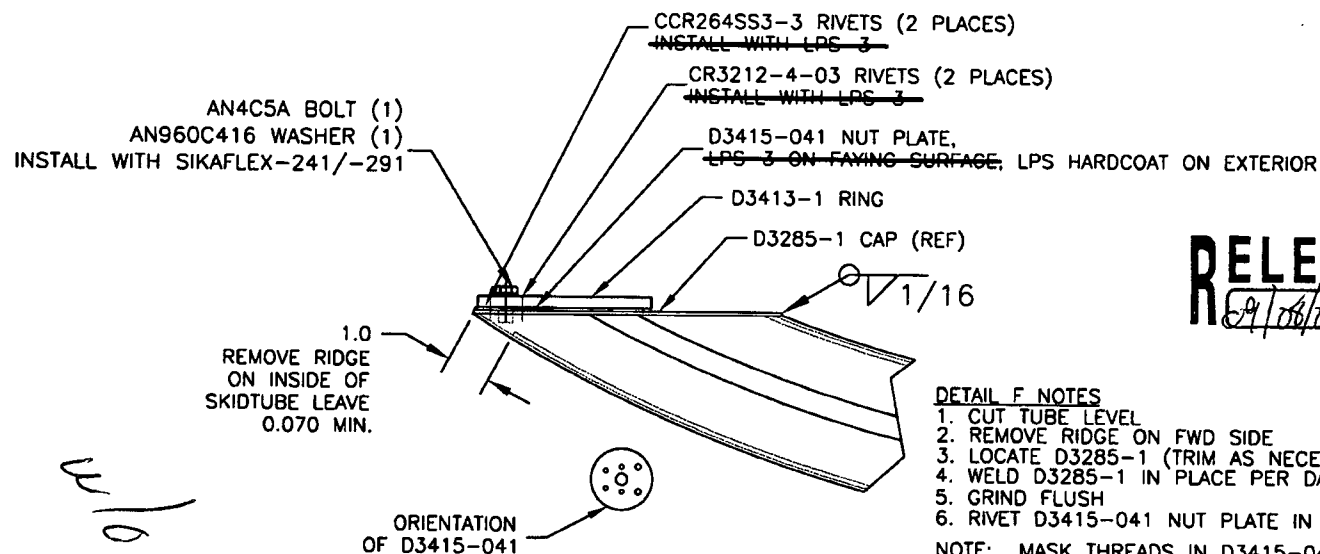
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>M</i>	APPROVED <i>MAP</i>	DE APPR. <i>H</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

NO 230

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 57358
Part number: DAC6-642-541
Description: Heat tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier: Lat. Phil Date of Test Coupon 10.05.05

Welder: Barclay Elliott Date of Test Coupon 10-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld